

Work Order ID 79425***79425***

Page 1

Item ID: D2571

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd Out 205

Start Date: 26/01/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: M.C.JDate: 12/01/2012

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	Rev E								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 79425 Double check by: FK 1-Machine Step No 1
per Folio FA051 and inspect per attached Dimension Sheets2-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets3-Machine
Step No 3 per Folio FA051 and inspect

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79425

79425

Page 2

January-26-12 8:08:11 AM

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd Out 205
 Start Date: 26/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 15/02/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check 0.00

130

QC

Memo

0.00

Quality Control

12/02/07

8

9

140 Chemical Conversion Coat per QSI005 4.1 0.00

140

HandFinish

Memo

0.00

Hand Finishing

8 BL 10-2-7.

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200 F

8-10

8X0 M/L 12/02/08

M 119480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79425

January-26-12 8:08:11 AM

79425

Page 3

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd Out 205
 Start Date: 26/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 15/02/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>432</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

8 x 6 10 1402/08
count

12/2/8 54 80

12/2/8 4.5 12/02/08

4.5 12/02/08
(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-26-12 8:08:14 AM

Page 1

Work Order ID: 79425

79425

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 26/01/2012

Required Date: 15/02/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	22.0000	1	12			

D6101-007

Saddle Billet

Location	Loc Qty	Loc Code
MAT045	22	
70680	3	
→ 76839	19	

71722 X 2

72228 X 1

5 *ack 12/02/01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 79425
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.502	.502	.502	.502		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.499	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.567	.567	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		.124	.124	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.254	.252	.252	.252		
S	0.115	0.135		.131	.130	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.956	2.956	2.956	2.956		
V	0.230	0.250		.240	.235	.235	.235		
W	0.115	0.135		.124	.123	.123	.123		
X	0.308	0.313		.309	.312	.312	.312		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.246	.246	.246		
AE	1.375	1.395		1.3882	1.390	1.386	1.386		
AF	0.115	0.135		.132	.135	.135	.135		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.257	.246	.246	.246		
AI	2.000	2.020		2.003	2.005	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: *AMF / RR*
 Date: 12/02/01 12.2.2

Audited by: *K.A*
 Date: 12/02/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 79425
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.003		
F	0.490	0.510		.502	.502	.502	.502		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		.124	.124	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.130	.130	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.956	2.956	2.956	2.956		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.124	.124	.124	.124		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.248	.248		
AE	1.375	1.395		1.386	1.386	1.386	1.386		
AF	0.115	0.135		.132	.132	.132	.132		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.251	.251	.251	.251		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									







Measured by:	TCS
Date:	12-2-3

Audited by:	B.A
Date:	12/02/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |

△ E

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	NEW ISSUE	
DS	PH	DART	DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2571	REV SHEET 1 OF
DATE 05.07.13	TITLE OUTER FWD SADDLE		SCALE 2:

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SUBJECT TO ASSIGNMENT

WITH 72 HOURS NOTICE
YOUR ORDER

NO. 79425465

12/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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